

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003400**Date Inspected:** 25-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skin plates**Summary of Items Observed:**

The names of ABF Certified Welding Inspector (CWI) are Mr. Liu Cheng, Mr. Xiao Jim Peng, Mr. Jiang Zi Men, Mr. Lai Quan and Mr. Wu Gui Cai.

Submerged Arc Welding (SAW) process on longitudinal stiffener plate and skin plate (Tower Bay#1 and Bay#2):

Caltrans QAI observed ZPMC welding operators performed semi-automatic SAW on the splice weld of ASTM

709 345 longitudinal stiffener plate P401 to P235 with 60mm wall thickness, weld# SSD1-SA173F/K-3A

(Bay#1), longitudinal stiffener plate P185 to P235 with 60mm wall thickness, weld# SSD1-SA173A/K-2B

(Bay#1), longitudinal stiffener plate P223A to P223B with 60mm wall thickness, weld# ESD1-SA216F/K-3B

(Bay#2), skin plate P839 to SA40 to P1276 to P689 with 60mm and 90mm wall thickness, weld#

ESD1-SA49A/D-11A (Bay#2), skin plate P838 to P853 to P591 with 60mm and 90mm wall thickness, weld#

ESD1-SA80B/E-24A (Bay#2), skin plate P351 to SA219 with 60mm wall thickness, weld#

SSD1-SA173A/JG-14B (Bay#1). The weld designed is a double -V-groove with welding conducted in the in flat

position (1G) with proper 4.8mm diameter wire feed electrode JW3 and flux/J1-B, made by China Company and

completed with approximate five pass. The parameters used for SAW welding of splice weld was conducted in

accordance with Caltrans approved WPS-B-T-2221-B-U3. The semi-automatic SAW was monitored and recorded

by ZPMC QC and ABF Certified Welding Inspector (CWI). Based on Caltrans QAI observations, no discrepancies were noted.

Summary of Conversations:

As Note within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

remedial efforts please contact Wahbeh Mazen (818)292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
----------------------	---------	-----------------------------

Reviewed By:	Carreon,Albert	QA Reviewer
---------------------	----------------	-------------